

# Abstract

[0049] A compound soft jaw for use in a machine vise has a replaceable jaw member into which the templates of the workpieces are cut. The compound soft jaw has a primary jaw member secured to a receiving plate of the machine vice. The first secondary jaw member is secured to the primary jaw member. The first secondary jaw member is machined to have a cutting template formed therein such that as the workpiece is secured within the machine vise, the workpiece is machined according to the template. Upon completion of machining of the workpiece, the first secondary jaw member is replaceable by a second secondary jaw member into which a second cutting template is formed. The primary jaw member has a height less than a height of the receiving plate. The secondary jaw member is placed on the primary jaw member and is forced into contact with a surface of the receiving. The secondary jaw member is then supported by the receiving plate, which prevents the secondary jaw member from movement during securing the workpiece. The second secondary jaw member may be the first secondary jaw member removed from the primary jaw member, rotated or inverted, and re-secured to the primary jaw member, with a second cutting template formed therein.